

Date: Tuesday, 10/06/2008 11:27:48 AM  
 User: Julie Lecocq

## Process Sheet

|                       |  |                  |                                |
|-----------------------|--|------------------|--------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services        | Drawing Name     | : FLOAT WEB                    |
| Job Number            | : 39770                                      |                  |                                |
| Estimate Number       | : 10791                                      |                  |                                |
| P.O. Number           | :  | Part Number      | : D3282041                     |
| This Issue            | : 10/06/2008 S.O. No. :                      | Drawing Number   | : D3282 REV C                  |
| Prsht Rev.            | : NC   | Project Number   | : N/A                          |
| First Issue           | : // Type : SKIDTUBES                        | Drawing Revision | : C                            |
| Previous Run          | : 39127                                      | Material         | :                              |
| Written By            | :  | Due Date         | : 17/06/2008 Qty: 250 Um: Each |
| Checked & Approved By | : <u>SL 08-6-10</u>                          |                  |                                |
| Comment               | : Est Rev:B 05.09.23 Procedure change KJ/JLM |                  |                                |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |           |
|-----|----------|-----------|
| 1.0 | D2792130 | EXTRUSION |
|-----|----------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

|                     |             |             |       |
|---------------------|-------------|-------------|-------|
| Qty                 | Part Number | Description | Batch |
| 1                   | D2792-130   | Extrusion   | 33518 |
| Identify as D3282-1 |             |             |       |

SL 8-6-10

|     |             |                       |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3282.

2- inspect for surface damage as per QSI0018

SL 8-6-10

|     |       |                                |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

m 08/09/28

②

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 08/09/28

②

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 11:27:48 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 39770

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/09/30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2

17-9-30

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 08-09-30 2

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B36345  
B 39163

3  
1

17-9-30

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 57.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M06574

67

M07242

47

17-9-30

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web  
A/RN/ALPS-3 M 103674

17-9-30 2

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/09/30 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 10/06/2008 11:27:48 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 39770

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L.G.

M 3-9-30

(2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                              |  |              |           |
|------------------------------|--|--------------|-----------|
| DART AEROSPACE LTD           |  | Work Order:  | 39770     |
| Description: Float Web       |  | Part Number: | D3282-041 |
| Inspection Dwg: D3282 Rev: C |  | Page 1 of 1  |           |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

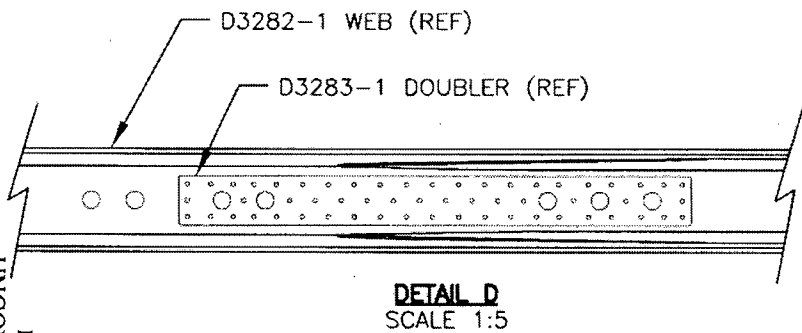
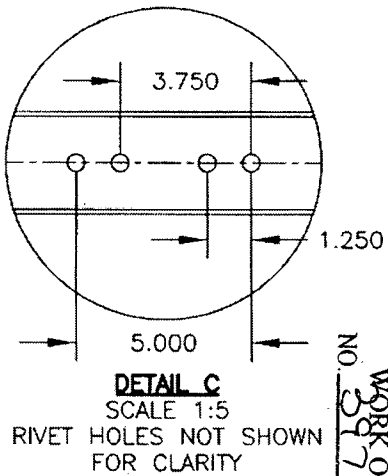
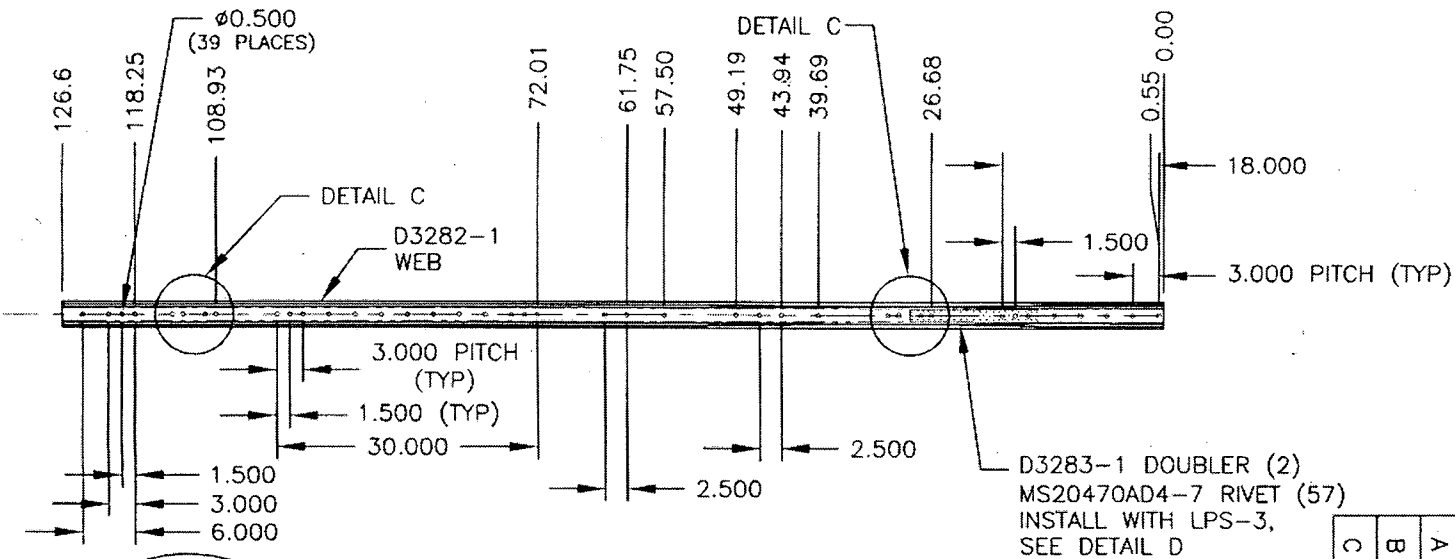
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 126.6             | +/-0.100  | 126.625          | ✓      |        |                      |          |
| 1.500             | +/-0.010  | 1.500            | ✓      |        |                      |          |
| 3.000             | +/-0.010  | 3.000            | ✓      |        |                      |          |
| 6.000             | +/-0.010  | 6.006            | ✓      |        |                      |          |
| 1.250             | +/-0.010  | 1.250            | ✓      |        |                      |          |
| 30.000            | +/-0.010  | 30.000           | ✓      |        |                      |          |
| 1.500             | +/-0.010  | 1.500            | ✓      |        |                      |          |
| 72.01             | +/-0.030  | 72.010           | ✓      |        |                      |          |
| 61.75             | +/-0.030  | 61.75            | ✓      |        |                      |          |
| 57.50             | +/-0.030  | 57.50            | ✓      |        |                      |          |
| 49.19             | +/-0.030  | 49.19            | ✓      |        |                      |          |
| 43.94             | +/-0.030  | 43.94            | ✓      |        |                      |          |
| 39.69             | +/-0.030  | 39.69            | ✓      |        |                      |          |
| 26.68             | +/-0.030  | 26.68            | ✓      |        |                      |          |
| 0.55              | +/-0.030  | .550             | ✓      |        |                      |          |
| 1.970             | +/-0.010  | 1.966            | ✓      |        |                      |          |
| 2.38              | +/-0.030  | 2.375            | ✓      |        |                      |          |
| 0.05              | +/-0.030  | .050             | ✓      |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

|                         |                        |                     |     |
|-------------------------|------------------------|---------------------|-----|
| Measured by: <i>JML</i> | Audited by: <i>SJS</i> | Prototype Approval: | N/A |
| Date: 08/09/28          | Date: 08/09/30         | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 07.04.02 | New Issue | KJ/JLM     | <i>[Signature]</i> |

# DART

|          |                    |          |                                  |                          |              |
|----------|--------------------|----------|----------------------------------|--------------------------|--------------|
| DESIGN   | CP                 | DRAWN BY | CP                               | DART AEROSPACE USA, INC. |              |
| CHECKED  | <i>[Signature]</i> | APPROVED | <i>[Signature]</i>               | DRAWING NO.              | REV. C       |
|          |                    |          |                                  | D3282                    | SHEET 1 OF 2 |
| DATE     |                    |          |                                  | TITLE                    | SCALE        |
| 05.08.09 |                    |          |                                  | FLOAT WEB, 206L/407      | 1:20         |
| A        |                    | 04.05.05 | NEW ISSUE                        |                          |              |
| B        |                    | 05.03.16 | MOVE HOLES, ADD D3390-1 DOUBLERS |                          |              |
| C        |                    | 05.08.09 | REMOVE D3390-1, NOW MACHINED     |                          |              |



RELEASED  
08.07.12 ~~16~~

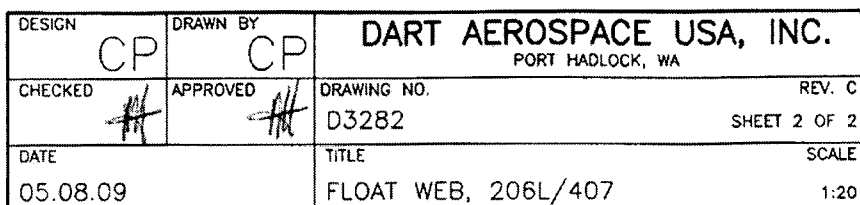
D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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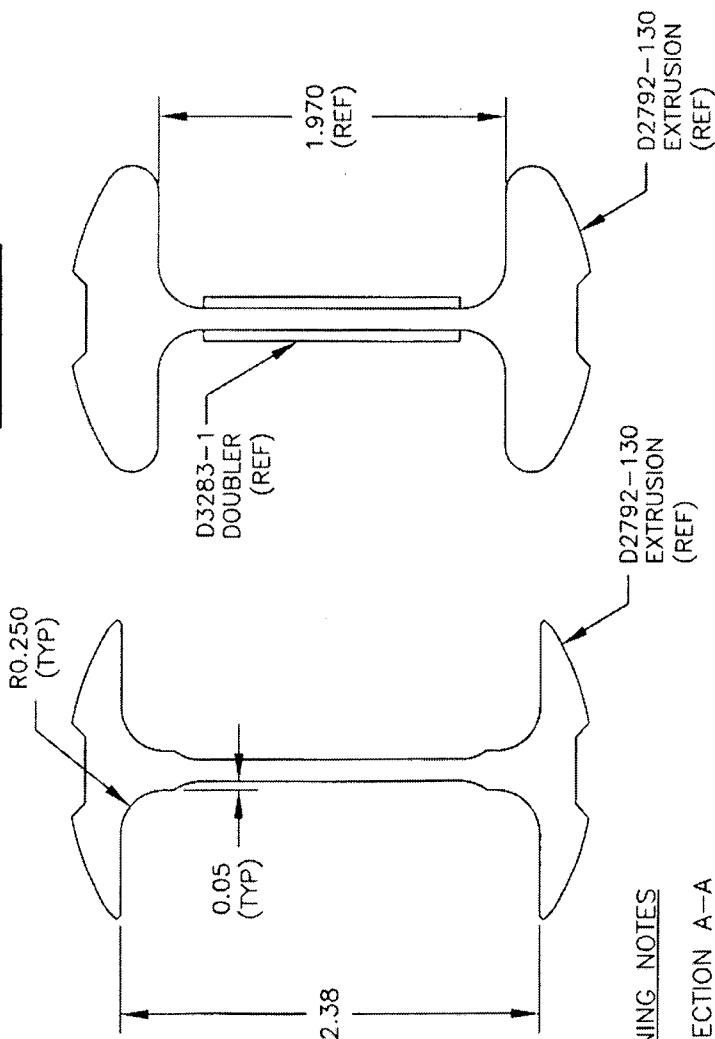




RELEASED

21140-50

**SECTION A-A**

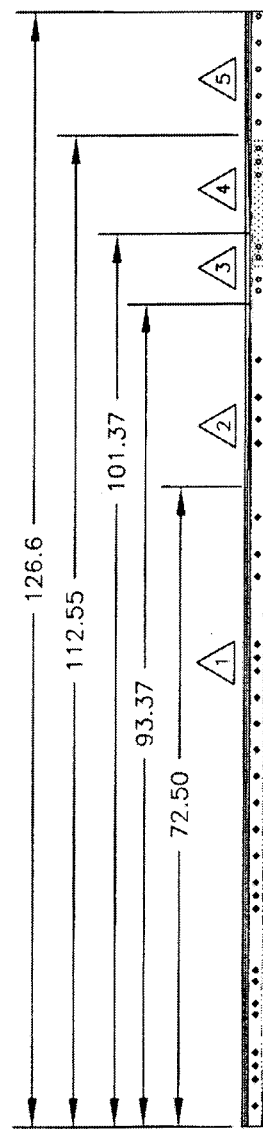


2  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDING  
WITHOUT NOTICE  
WORK ORDER  
NO. 51770

D3282-1 MACHINING NOTES

- (REF)

  - 1 UNIFORM SECTION A-A
  - 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
  - 3 UNIFORM SECTION B-B
  - 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A  
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,  
SEE DETAIL D FOR REFERENCE
  - 5 UNIFORM SECTION A-A
  - 6 R1.00 BETWEEN SECTIONS



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